

## **Historic, Archive Document**

Do not assume content reflects current scientific knowledge, policies, or practices.



QTS 1975  
Aiu54

# ISSUANCES

of the

**Meat and Poultry Inspection Program**

August 1977



**F  
S  
Q  
S**

## CONTENTS

Changes

77/8, Meat and Poultry  
Inspection Manual

77/8, Meat and Poultry  
Inspection Regulations

**UNITED STATES DEPARTMENT OF AGRICULTURE  
Food Safety and Quality Service  
Meat and Poultry Inspection Program  
Washington, D.C. 20250**



UNITED STATES DEPARTMENT OF AGRICULTURE  
FOOD SAFETY AND QUALITY SERVICE  
MEAT AND POULTRY INSPECTION PROGRAM  
WASHINGTON, D.C. 20250

## Meat and Poultry Inspection Manual

August 1977

CHANGE: 77-8

### MAINTENANCE INSTRUCTIONS

| Remove Page      | Insert Page      | Numbered |
|------------------|------------------|----------|
| 125 through 130b | 125 through 130b | 77-8     |
| 139 and 140      | 139 through 140a | 77-8     |
| 191 through 194  | 191 through 194  | 77-8     |

#### Pen and Ink Changes

Page 7, section 5.8, paragraph 1, line 6, change "922-5" to "922.1."

Page 261b, section 22.47(a), paragraph 2, line 2, insert the words "fresh or frozen" between the words "for" and "meat."

#### Bulletins Deleted

Changes on pages 125 through 130b delete MPI Bulletin 77-101.

Changes on pages 191 through 194 delete MPI Bulletin 424.

August 16, 1977

**(b) Thermocouples**

They may be used to record temperatures. However, their accuracy shall be checked against an official (standard) thermometer. Placing thermocouples in product shall be under inspector's supervision.

**18.5 LOT INSPECTION; SAMPLING**

Sampling finished product is necessary to assure compliance with regulations, approved fabrication procedures, and labeling. Thus, the inspector shall sample production lots, as required, and submit samples to the laboratory for analytical verification of product composition (fat content, added water, restrictive additives, etc.).

Inspector's supervisor should assure that product sampling is adequate and should periodically take check samples for laboratory analysis.

**18.6 APPROVED QUALITY CONTROL****(a) Plant**

Management may develop quality control systems to assure product compliance. Such systems have been very effective in various operations (canning, curing and smoking, sausage preparation, etc.).

To obtain approval to use a quality control system, management should:

1. Develop effective control procedures for all or some production phases to assure product compliance with regulations and approved fabrication methods.
2. Through the inspector, submit detailed procedure description to STS-SDS for approval. Provide copy of approved procedure for inspector's file.
3. Apply approved procedure in all details to respective production.
4. Designate product lots or groups for sampling.
5. Randomly select required number of samples according to applicable sampling plan.

6. Inspect samples and obtain laboratory results.

7. Classify defects according to defect criteria and laboratory results with sample zones (limits).

8. Keep records current for inspector's review.

9. Take required action (retain, rework, resample, etc.) to bring product lots represented by sample into compliance.

10. Reinspect retained and/or reconditioned lots according to applicable criteria.

11. Change sampling plans to reflect current production control requirements.

**(b) Inspector**

When plant uses an approved quality control system, inspector's responsibility does not cease. He shall monitor plant's adherence to and effectiveness of such control, as outlined in the following subparts.

The inspector shall:

1. Review, evaluate and recommend approval or disapproval of plant quality control.
  2. Familiarize himself with details of approved procedure.
  3. Monitor plant adherence to procedure and evaluate its effectiveness.
  4. Verify proper lot designation, sample size, and random sampling.
  5. Check defects or laboratory results classification.
  6. Submit verification samples, correlate, and discuss results with plant management.
  7. Frequently check records to verify results.
  8. Assure adequacy of corrective action and proper disposition of retained product.
  9. Evaluate procedure for sampling current production.
  10. When plant refuses to adhere to approved procedure, void approval, revert to lot inspection and notify supervisor.
-



## BONELESS MEAT REINSPECTION (MEAT)

## Subpart 18-B

(Regs: M-318; P-Subpart O)

## 18.9 PRODUCT

- \* Boneless meat--chucks for manufac-
  - \* turing, mixture of wholesale cuts, and
  - \* trimmings--from cattle, calves,
  - \* sheep, goat, and swine carcasses
- shall be reinspected before shipping as outlined in this subpart.

Exception! Inside and outside rounds, knuckles, loin strips, plates, navels, shoulder clods, briskets, flanks, tenderloins, chucks, hams, picnics, pork loins, and other whole-sale cuts are excluded if packed and so labeled.

## 18.10 PLANT RESPONSIBILITY

Plant management shall provide adequate help, facilities, and equipment for reinspection.

## 18.11 PROCEDURE

Sampling plans and criteria for disposition of lots of boneless meat shall be as prescribed in Table 18.1.

Reinspection procedures may be divided into "lot inspection" and "online inspection."

## (a) Lot Inspection

Plant management is responsible for grouping product into coded lots acceptable to the inspector in charge, and for adequately identifying and reconditioning rejected lots.

The inspector shall:

1. After lot is completely assembled, determine its size (in pounds), and select indicated sampling plan from Table 18.1. The inspector may select a larger sample for greater assurance.

2. Randomly select required number

of cartons from the lot in proportion to different code marks, and remove 12-pound sample units from the cartons.

3. Examine product thoroughly, classify defects--use defect criteria table--and determine acceptance or rejection according to sampling plan.

4. After reconditioning, reinspect rejected lot at a sampling rate one plan higher than the original. \*

5. If applicable, record number of defects by container code on MP Form 450 and file for 1 year.

Common source product. When product from one boning source is taken to two separate areas (further processing, shipping), such product is considered "common source."

Also, if several boning tables combine product to a single belt and product is diverted to different areas, the product is all "common source."

The inspector shall:

1. Examine the product as outlined under "Lot Inspection" on each line.

2. After inspecting 60,000 pounds or 2 days' production (whichever is less) without rejection, examine as above only product diverted for shipment and apply normal surveillance over common source product to be used for further processing. Sampling plan will be based on total production (including product diverted to further processing).

3. If a lot is rejected, return to lot inspection of all lines until 60,000 pounds or 2 days' production is inspected without rejection.

## (b) Online Inspection

(1) Plant. To qualify, plant must (1) have good history of producing clean product, (2) be approved by area supervisor, and (3) assign competent personnel to:

1. Sample product, examine sample unit, and properly classify defects. Sampling point shall be close to where product enters the containers.

2. Draw a 30-pound sample unit from each production line, or common source, at least every half hour (average).

Table 18.1 - Sampling Plans

| Lot size<br>(pounds)                        | Plan<br>No.      | Step<br>No. | Sample<br>units | Major    |          | Critical |          | Total    |          |
|---|------------------|-------------|-----------------|----------|----------|----------|----------|----------|----------|
|   |                  |             |                 | Ac       | Re       | Ac       | Re       | Ac       | Re       |
| 1,000 or less                               | 5 <sup>1/</sup>  | -           | 3               | 0        | 1        | 0        | 1        | 1        | 2        |
| 8,000 or less                               | 10               | -           | 6               | 0        | 1        | 0        | 1        | 5        | 6        |
| 8,000 to (but not<br>including) 24,000      | 15               | 1           | 9               | 0        | 2        | 0        | 1        | 4        | 8        |
|   |                  | 2           | <u>3</u>        | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> |
| Total.....                                  |                  |             | 12              | 1        | 2        | 0        | 1        | 8        | 9        |
| 24,000 to (but not<br>including) 60,000     | 20               | 1           | 15              | 0        | 3        | 0        | 1        | 6        | 12       |
|   |                  | 2           | <u>15</u>       | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> |
| Total.....                                  |                  |             | 30              | 2        | 3        | 0        | 1        | 18       | 19       |
| 60,000 to (but not<br>including) 240,000    | 25               | 1           | 22              | 0        | 4        | 0        | 1        | 9        | 16       |
|   |                  | 2           | <u>25</u>       | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> |
| Total.....                                  |                  |             | 47              | 3        | 4        | 0        | 1        | 26       | 27       |
| 240,000 to (but not<br>including) 500,000   | 30               | 1           | 27              | 0        | 4        | 0        | 1        | 10       | 19       |
|   |                  | 2           | <u>40</u>       | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> |
| Total.....                                  |                  |             | 67              | 4        | 5        | 0        | 1        | 35       | 36       |
| 500,000 to (but not<br>including) 1,000,000 | 35               | 1           | 33              | 0        | 5        | 0        | 2        | 12       | 21       |
|   |                  | 2           | <u>56</u>       | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> |
| Total.....                                  |                  |             | 89              | 5        | 6        | 1        | 2        | 45       | 46       |
| 500,000 to (but not<br>including) 1,000,000 | 40 <sup>2/</sup> | 1           | 40              | 0        | 6        | 0        | 2        | 15       | 25       |
|   |                  | 2           | <u>71</u>       | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> |
| Total.....                                  |                  |             | 111             | 6        | 7        | 1        | 2        | 56       | 57       |
| 1,000,000 and over                          | 45               | 1           | 72              | 3        | 7        | 0        | 2        | 32       | 41       |
|   |                  | 2           | <u>48</u>       | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> |
| Total.....                                  |                  |             | 120             | 6        | 7        | 1        | 2        | 60       | 61       |
| 1,000,000 and over                          | 50 <sup>2/</sup> | 1           | 120             | 4        | 9        | 0        | 3        | 51       | 63       |
|   |                  | 2           | <u>100</u>      | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> | <u>-</u> |
| Total.....                                  |                  |             | 220             | 11       | 12       | 2        | 3        | 105      | 106      |

1/ To be used only upon request of plant management or import broker.

2/ Alternate plan for the applicable lot size for reinspection of rejected lots and for lots consisting of numerous marks.

3. Complete MP Form 450-1. Evaluate individual (30 pound) sample unit limits and cumulative total limits.

4. Reject, hold, and recondition product when defects exceed limits. Immediately inform the inspector. If he is on patrol assignment, notify at his next visit.

5. Before resuming online inspection, follow lot inspection procedures until 60,000 pounds or 2 days' production is completed (whichever is less).

6. File completed MP Form 450-1 for 1 year. The file must be readily available to MPI personnel.

(2) Inspector. He shall (1) assure that plant personnel properly judges defects; (2) inspect a 30-pound sample unit four times a day or two 30-pound sample units on each patrol visit, or product available at time of visit; (3) observe carcass cleanliness before boning; (4) if a rejection limit is reached, confirm that all product on hand is cleaned and reinspected; (5) if unacceptable product is passed by plant personnel, enforce product lotting and holding, and insist on lot-by-lot inspection under his close surveillance until he feels plant inspection may resume; (6) assure that plant's rejection is followed by lot inspection until 60,000 pounds or 2 days' production of boneless product is produced before resuming online inspection.

#### 18.12 SHIPPING; RECEIVING

Boneless meat and bulk-packed ground product in closed and marked containers (not casings) need not be shipped under seal to other plants or warehouse.

#### \* (a) Record

The shipping and receiving plant shall:

1. Maintain records of each boneless meat shipment. Include date, product description, quantity, number

of pieces or units, and origin or destination.

2. Provide such records for review when requested by MPI employees.

#### (b) Species Identification Sampling \*

Inspector shall sample for species identification as directed by RD. Sampling should include lots of domestic or imported boneless meat from: (1) warehouses, (2) other plants, (3) any source when suspicion arises from character of product, condition of container, or lack of proper identification.

Samples shall be submitted to the microbiology laboratory (see Part 23).

#### 18.13 DEFECT CRITERIA

Use Chart 18.1 for classifying the defects found on boneless meat from cattle, calves, sheep, and goats. Use Chart 18.1-A for classifying the defects found on boneless meat from swine. \*



**Chart 18.1 - Defect criteria (for sample unit).**  
**Meat from cattle, calves, sheep, goats, and equines.**

\*

\*

| Defects                       |  |                |      |
|-------------------------------|--|----------------|------|
| Type                          | Description  | Class          | Code |
| Blood clots                   | Less than 1½" in greatest dimension  | *Insignificant |      |
|                               | 1½" to 6" in greatest dimension.   | Minor          | 100  |
|                               | More than 6" in greatest dimension, or numerous (over 5) minor blood clots in one sample unit (1/) not seriously affecting product usability.  | Major          | 101  |
|                               | One or more of a number or size seriously affecting product usability.   | Critical       | 102  |
| Bruises                       | Less than 1" in greatest dimension and less than ½" deep.  | *Insignificant |      |
|                               | 1" to 2½" in greatest dimension or ½" to 1" deep.  | Minor          | 100  |
|                               | More than 2½" in greatest dimension or more than 1" deep, or numerous (over 5) minor bruises in one sample unit (1/) not seriously affecting product usability.  | Major          | 101  |
|                               | One or more of a number or size seriously affecting product usability  | Critical       | 102  |
| Bone fragments                | (1) Thin bone scrapings less than 1/32" thick x 1/8" wide x 3" long attached to muscle tissue. (2) Thin flexible bone slivers, either attached to or detached from muscle tissue less than 1/4" wide and 3/4" long. (3) Thin bone fragments or chips either attached to or detached from muscle tissue that crumble easily and are less than 3/4" in greatest dimension.                                       | *Insignificant |      |
|                               | Less than 1½" in greatest dimension.   | Minor          | 150  |
|                               | 1½" or more in greatest dimension, or numerous (over 5) minor fragments in one sample unit (1/) not seriously affecting product usability.   | Major          | 151  |
|                               | One or more of a number or size seriously affecting product usability.   | Critical       | 152  |
| Bone slivers (from rib)       | Less than 3" long and less than 1/4" wide and flexible bone chip from a rib end more than 3/4" in greatest dimension that is thin and crumbles easily, and with or without attached muscle tissue.   | Minor          | 150  |
| Detached cartilage, ligaments | Less than 1" long  | *Insignificant |      |
|                               | 1" or more long and free of muscle tissue. (See also bone slivers).  | Minor          | 200  |
|                               | Numerous (over 5) minor defects in one sample unit (1/) not seriously affecting product usability.   | Major          | 201  |
|                               | Defects of number seriously affecting product usability.   | Critical       | 202  |
| Extraneous material           | Minute specks or dust. If affecting product usability, score them under codes 800, 801, 802.<br>Pieces of plastic or paper wraps or any soft material less than ½".  | *Insignificant |      |
|                               | Paper or plastic wraps ½" to 7 square inches; a single piece covering an area equal to that of a circle 1/8" to 1/2" in diameter; a wild oat or other grass beard over 3/8" long or 3 or more pieces of wild oats or grass beards 1/8" to 3/8" long on one meat piece and without inflammation.  | Minor          | 300  |
|                               | Blunt piece of wood 1" or more long; paper or plastic over 7 square inches; single piece of material covering an area greater than that of a circle with a diameter exceeding ½"; small insects without insanitation. Numerous (over 5) minor defects in a sample unit not seriously affecting product usability; any substance causing minor bodily irritation or discomfort (chemicals, hard objects, etc.). | Major          | 301  |
|                               | Any substance causing injury or illness (poisonous or toxic chemicals, sharp pieces of metal, glass, hard plastic, etc.); large insects, insects associated with insanitation, or any material of number or size seriously affecting product usability.  | Critical       | 302  |

\*

\*\*\*

Note: See footnote at end of chart.

\*

Chart 18.1 - Continued

\*

## Defects

| Type                     | Description  | Class          | Code |
|--------------------------|--|----------------|------|
| Hair<br>Hide<br>Wool     | Hide (with or without hair) or wool less than $\frac{1}{2}$ " in greatest dimension. A total of five to 10 single strands of hair or wool. Total number of hairs, divide by 10 and round off to nearest whole number to determine total hair defects. For example: 34 hairs equal 3 defects and 35 hairs equal 4 defects. When second step is necessary, total number of hairs in step one and two, divide by 10 and round off to nearest whole number as described above. Also a cluster of hair (strands too numerous to count) in one area. | Minor          | 400  |
|                          | Hide (with or without hair) or wool $\frac{1}{2}$ " or more in greatest dimension; numerous (over 25) single strands of hair in one sample unit ( $\frac{1}{1}$ ); numerous (over 5) clusters of hair in one sample unit ( $\frac{1}{1}$ ), provided none of above seriously affect product usability.   | Major          | 401  |
|                          | Hair, hide or wool of amount seriously affecting product usability.  | Critical       | 402  |
| Ingesta                  | Amount equal to area of a circle $\frac{1}{2}$ " or less in diameter.  | Major          | 251  |
|                          | Amount equal to area of a circle more than $\frac{1}{2}$ " in diameter.  | Critical       | 252  |
| Off condition            |  | Critical       | 452  |
| Parasitic lesions        | Parasites not transmissible to man. One, two, or three closely associated lesions on one piece of meat - Score as one lesion (ovine only). First lesion found in a sample.   | Minor          | 500  |
|                          | Each succeeding parasitic lesion in the sample.  | Major          | 501  |
| Pathologic lesions       | Any lesion (not evident on post-mortem inspection) not seriously affecting product acceptability.  | Major          | 501  |
|                          | Any lesion unless excepted as noted under Code 501.  | Critical       | 502  |
| Stains, Discolored areas | Very light stains of any size or stains covering an area less than that of a circle $\frac{1}{2}$ " in diameter  | *Insignificant |      |
|                          | Equal to area of a circle $\frac{1}{2}$ " to $1\frac{1}{2}$ ".   | Minor          | 600  |
|                          | Equal to area of a circle greater than $1\frac{1}{2}$ " in diameter; numerous (over 5) minor stains in one sample unit (12 pounds) not seriously affecting product usability ( $\frac{1}{1}$ ).  | Major          | 601  |
|                          | Minor or major areas of a number seriously affecting product usability.  | Critical       | 602  |
| Other                    | Defect that individually or in aggregate affects product appearance, but not its usability.  | Minor          | 800  |
|                          | Defect that individually or in aggregate materially affects product usability.   | Major          | 801  |
|                          | Defect that individually or in aggregate seriously affects appearance or usability of product.   | Critical       | 802  |

\*No significance in product wholesomeness; do not score.

 $\frac{1}{1}$  Do not score as minor also.

\* Chart 18.1-A - Defect criteria (for sample unit). Meats from swine carcasses. \*

| Defects                       |  |                |      |
|-------------------------------|--|----------------|------|
| Type                          | Description  | Class          | Code |
| Blood clots                   | Less than 1½" in greatest dimension  | *Insignificant |      |
|                               | 1½" to 6" in greatest dimension.   | Minor          | 100  |
|                               | More than 6" in greatest dimension, or numerous (over 5) minor blood clots in one sample unit (1/) not seriously affecting product usability.  | Major          | 101  |
|                               | One or more of a number or size seriously affecting product usability.   | Critical       | 102  |
| Bruises                       | Less than 1" in greatest dimension and less than ½" deep.  | *Insignificant |      |
|                               | 1" to 2½" in greatest dimension or ½" to 1" deep.  | Minor          | 100  |
|                               | More than 2½" in greatest dimension or more than 1" deep, or numerous (over 5) minor bruises in one sample unit (1/) not seriously affecting product usability.  | Major          | 101  |
|                               | One or more of a number or size seriously affecting product usability  | Critical       | 102  |
| Bone fragments                | (1) Thin bone scrapings less than 1/32" thick x 1/8" wide x 3" long attached to muscle tissue. (2) Thin flexible bone slivers, either attached to or detached from muscle tissue less than 1/4" wide and 3/4" long. (3) Thin bone fragments or chips either attached to or detached from muscle tissue that crumble easily and are less than 3/4" in greatest dimension.                                     | *Insignificant |      |
|                               | Less than 1½" in greatest dimension.   | Minor          | 150  |
|                               | 1½" or more in greatest dimension, or numerous (over 5) minor fragments in one sample unit (1/) not seriously affecting product usability.   | Major          | 151  |
|                               | One or more of a number or size seriously affecting product usability.   | Critical       | 152  |
| Bone slivers (from rib)       | Less than 3" long and less than 1/4" wide and flexible bone chip from a rib end more than 3/4" in greatest dimension that is thin and crumbles easily, and with or without attached muscle tissue.   | Minor          | 150  |
| Detached cartilage, ligaments | Less than 1" long  | *Insignificant |      |
|                               | 1" or more long and free of muscle tissue. (See also bone slivers).  | Minor          | 200  |
|                               | Numerous (over 5) minor defects in one sample unit (1/) not seriously affecting product usability.   | Major          | 201  |
|                               | Defects of number seriously affecting product usability.   | Critical       | 202  |
| Extraneous material           | Minute specks or dust. If affecting product usability, score them under codes 800, 801, 802.   | *Insignificant |      |
|                               | Pieces of plastic or paper wraps or any soft material less than ½".  |                |      |
|                               | Paper or plastic wraps ½" to 7 square inches; a single piece covering an area equal to that of a circle 1/8" to 1/2" in diameter; a wild oat or other grass beard over 3/8" long or 3 or more pieces of wild oats or grass beards 1/8" to 3/8" long on one meat piece and without inflammation.  | Minor          | 300  |
|                               | Blunt piece of wood 1" or more long; paper or plastic over 7 square inches; single piece of material covering an area greater than that of a circle with a diameter exceeding ½"; small insects without sanitation. Numerous (over 5) minor defects in a sample unit not seriously affecting product usability; any substance causing minor bodily irritation or discomfort (chemicals, hard objects, etc.). | Major          | 301  |
|                               | Any substance causing injury or illness (poisonous or toxic chemicals, sharp pieces of metal, glass, hard plastic, etc.); large insects, insects associated with sanitation, or any material of number or size seriously affecting product usability.  | Critical       | 302  |
| * * *                         |  |                |      |

Note: See footnote at end of chart.



| Defects  |  |                |      |
|--|--|----------------|------|
| Type   | Description  | Class          | Code |
| Skin<br>Hair<br>Hair roots                     | Skin (with or without hair or visible hair roots) individually or in aggregate less than 1 square inch.  | *Insignificant |      |
|  | Skin (with or without hair or visible hair roots) individually or in the aggregate 1 square inch to 3 square inches. A total of 2 or 3 single strands of hair or 5 to 10 visible hair roots. Total number of hairs or visible hair roots in sample divide by 3 for hairs or 10 for visible hair roots and round off to nearest whole number. For example, 10 hairs equal 3 defects. Thirty-eight visible hair roots equal 4 defects. When second step is necessary, total the hair or visible hair roots from both steps. Also, cluster of hair or visible hair roots (strands too numerous to count) in one area. | Minor          | 400  |
|  | Skin with or without hair or visible hair roots individually or in aggregate over 3 square inches; numerous (over 13) single strands of hair in one sample unit (1/), provided none of above seriously affect product usability.   | Major          | 401  |
|  | Hair, skin, or visible hair roots seriously affecting product usability.   | Critical       | 402  |
| Ingesta  | Amount equal to area of a circle 1/2 inch or less in diameter.   | Major          | 251  |
|  | Amount equal to area of a circle more than 1/2 inch in diameter.   | Critical       | 252  |
| Off condition                                  |  | Critical       | 452  |
| Lips<br>Ear canals<br>Teeth<br>Kidney<br>Liver | Any sample unit containing tooth or teeth. Ear canal(s), lip with or without teeth marks, piece(s) of kidney or liver.   | Major          | 501  |
| Pathologic lesions                             | Any lesion (not evident on post-mortem inspection) not seriously affecting product acceptability.  | Major          | 501  |
|  | Any lesion unless excepted as noted under Code 501   | Critical       | 502  |
| Stains, Discolored areas                       | Very light stains of any size or stains covering an area less than that of a circle 1/2 inch in diameter.  | *Insignificant |      |
|  | Equal to area of a circle 1/2 inch to 1 1/2 inch.  | Minor          | 600  |
|  | Equal to area of a circle greater than 1 1/2 inch in diameter; numerous (over 5) minor stains in one sample unit (12 pounds) not seriously affecting product usability (1/).   | Major          | 601  |
|  | Minor or major areas of a number seriously affecting product usability.  | Critical       | 602  |
| Lung tissue                                    | Any amount.  | Critical       | 652  |
| Other  | Defect that individually or in aggregate affects product appearance, but not its usability.  | Minor          | 800  |
|  | Defect that individually or in aggregate materially affects product usability.   | Major          | 801  |
|  | Defect that individually or in aggregate seriously affects appearance or usability of product.   | Critical       | 802  |

\*No significance in product wholesomeness; do not score.

1/ Do not score as minor also.



without limitation.

b. Pieces of cooked and/or smoked meat may be used without limitation if properly identified in the ingredient statement.

c. Pieces of uncooked, cured pork from primal parts may be used without limitation, if properly identified in the ingredient statement.

d. Bacon may be used in cooked sausages covered by section 319.180 of the regulations. However, it is limited to 10 percent of the meat; or meat and meat products; or meat, meat byproducts, and poultry products in a sausage formula.

e. Sausage products in edible collagen casings may be used in similar finely comminuted products without limitation and need not be peeled.

f. Finished cooked sausage in natural casings may be used in similar finely comminuted products without limitation, except sausages in bungs, middles, beef rounds, bladders, or stomachs must be stripped of the casings before use. Also, natural casings of any type that break during the stuffing operations should not be included in emulsions.

g. Semi-dry/dry sausage (other than rework that occurs during stuffing) may only be used in products processed to reach an internal temperature of 140° F. for 50 minutes, 145° F. for 5 minutes, or 150° F. or more momentarily. Rework which occurs during stuffing may only be used in subsequent production of semi-dry or dry sausages.

Processors desiring to use rework from semi-dry/dry sausage in other products may submit their written proposal through the area supervisor to STS-ISR.

### (b) Precooked Product

Precooked specialty items stuffed in natural casings--pork stomachs, bungs, bladders, etc.--must be reheated to an internal temperature of 66° C. (150° F.) or higher after stuffing.

Exception. This requirement may be waived whenever the inspector in charge is satisfied that the product was stuffed into natural casings which were held a minimum of 14 consecutive days in a brine solution of at least 26 percent salt by weight, or a salometer reading of 100°, or they were held a minimum of 21 consecutive days in a covering of salt (rock, flake or granulated.)

### (c) Ingredient Calculation

The following examples show methods of calculating ingredients in cooked sausage. They are based on 10 percent added water by weight. In practice "added water" is calculated amount of water based on standard protein-moisture ratio. If the calculated amount of ingredients indicates the plant formula may result in finished product violation, the inspector should advise plant management, observe product preparation, establish true finished product yield, calculate the true percentage of ingredient based on the actual yield, and if violation is indicated, retain product and submit samples to the laboratory.

Example 1. Cooked sausage (Standard for NFDM 3 1/2 percent; added water 10 percent).

Problem. How much NFDM may be added to a batch containing 400 pounds of meat, seasonings, and other ingredients excluding ice (water) and extenders?

Procedure:

$100\% - (3\frac{1}{2}\% + 10\%) = 86.5\% = 0.865$ ;  $400 \div 0.865 = 462.4$ ;  $462.4 \times 0.035$  or  $3\frac{1}{2}\% = 16.2$ . The 16.2 pounds is the weight of NFDM that may be added if other extenders are not used.

Example 2. Regular cooked sausage (ISP = 2 percent or NFDM = 3.5 percent).

Problem. How much NFDM may be used if 4 pounds of ISP are also to be added to a batch with an ingredient weight of 380 pounds (excluding water

and extenders)?

Procedure.

1. Determine weight excluding water and extenders as if the only extender is ISP.

2. Find theoretical finished weight:  $380 \div 0.88 [100 - (10\% \text{ added water} + 2\% \text{ ISP})] = 431.8 \text{ lbs.}$

3. Find maximum amount of ISP permitted:  $431.8 \times 0.02 = 8.6 \text{ lbs.}$

4. Find what equivalent amount of NFDM is permitted after 4 pounds of ISP that could be added. The equivalent amount of NFDM =  $\frac{3.5}{2} \times 4.6 = 8.05 = 8.1 \text{ lbs.}$

Answer: If 4 pounds of ISP are added, then maximum NFDM that can be added in this formula is 8.1 pounds.

Example 3. Frankfurters

Problem. How much ISP may be added to a batch beginning with 105 pounds of meat seasoning, and other dry ingredients with 2 pounds of NFDM?

Procedure.

1. Find theoretical finished weight as in previous examples:  $100 - (3 \frac{1}{2} + 10) = 86 \frac{1}{2}\%$ .  $105 \div 0.865 = 121.4 \text{ pounds.}$

2. Find total allowable NFDM:  $121.4 \times 0.035 = 4.2 \text{ pounds.}$

3. Find equivalent amount of ISP that can be added with 2 pounds of NFDM:  $4.2 - 2 = 2.2$ . Equivalent ISP =  $\frac{2}{3.5} \times 2.2 = 1.3 \text{ lbs.}$

Answer. 1.3 pounds of ISP may be used with 2 pounds of NFDM in the formula.

#### (d) Corn syrup, sorbitol solids

Corn syrup and/or sorbitol solids are permitted in cooked sausage not to exceed 2 percent alone or in combination.

To determine the maximum amount of corn syrup and/or sorbitol solution permitted, calculate the weight of dry solids permitted and convert to weight of liquid.

Example. Product is to contain corn syrup solids and cereal, or sorbitol and cereal. Weight of ingredients other than water, cereal, and

corn syrup solids or sorbitol is 260 pounds.

Problem. Find maximum amount of either corn syrup and cereal or sorbitol and cereal permitted in formulation.

Procedure.

1.  $260 \text{ pounds} = 100\% - (10 + 3 \frac{1}{2} + 2) = 84 \frac{1}{2}\%$ .

2. Solve for finished weight:  $260 \div 0.845 = 307.7 \text{ lbs.}$

3. Calculate weights allowed: Corn syrup solids =  $307.7 \times 0.02 = 6.2 \text{ lbs.}$

Sorbitol solids =  $307.7 \times 0.02 = 6.2 \text{ lbs.}$

Cereal =  $307.7 \times 0.035 = 10.8 \text{ lbs.}$

4. If corn syrup is used, consider syrup as 80% dry solids:

$6.2 \times 0.80 = 7.75 \text{ lbs. corn syrup.}$

5. If sorbitol is in solution, the U.S.P. or N.F. solution is 70% solids:  $6.2 \div 0.70 = 8.9 \text{ lbs. N.F. sorbitol solution.}$

Remember that water is a part of any syrup or solution. Combinations may be calculated as in examples 2 and 3 of 18.24(c).

#### (e) Definitions and Explanations for Lot Inspection

(1) Lot. A shift's production of one size and basic formula or specification.

(2) Sampling. Divide monthly (or weekly or daily) production by 35,000 to determine the number of lots to sample for both normal and tightened inspections. However, regardless of production volume, samples must be taken as limited by Table 18.3. Sample the lots most likely to be in violation. Sampling rate may not be increased for the purpose of hastening the return to normal criteria. Select three 1-pound units of finished, unpackaged product. Each unit should represent different batches from one lot (do not composite). The inspector must be familiar with production methods and confirm that operations indicate compliance

with approved procedures.

(3) **Retail samples.** Samples may be taken at retail level as directed.

(4) **Records.** One scoresheet (MP Form 492) for fat and one for added water must be maintained for all cooked sausage products combined that are subject to both fat and added water limitations. A separate

The reverse of this page is intended to be blank.





serve a useful purpose. Do not indiscriminately request laboratory analysis.

13. Include name of product as it will be labeled and list of ingredients in descending order or predominance. When proprietary mixtures are sampled, record list of ingredients as they are on shipping container, name and address of manufacturer, and purpose for which the material is intended. Also, include any information of value to the analyst and requests for additional information.

When a sample is sent to the laboratory for a special purpose, a notation must be made on laboratory form to that effect, or bear reference to a letter or correspondence indicating need for such request.

14. When analysis is requested for sample other than meat and meat food product, the laboratory will check whether the sample is in compliance.

15-20. For laboratory use only.

Tear Strip. The inspector shall (1) record type of product, date, brief nature of request (protein, moisture, added water, fat, etc.), retain tag number if product retained, and signature; (2) remove and attach original to sample with rubber band. Preprinted sample number and type of product must be readily legible without removing the tear strip; (3) retain second copy in inspector's office until laboratory results are received, then discard (if desired); (4) not separate other copies from MP Form 22 (or tear strips).

Reverse side, 21-23--self-explanatory.

(a) Mailing to Laboratory. Place remaining copies in a plastic bag to prevent leakage stains.

Pack them in shipping container with sample, and avoid form wrinkling.

To facilitate laboratory's return of the form, enclose a franked, self-addressed envelope.

checks "In Compliance" box in block 14 for all products, and sends copies 1 and 2 to inspector. Inspector sends copy 2 to area supervisor. \*

(2) Violations. Laboratory checks "Action by Inspector" box in block 14, and sends copies 1, 2, and 4 to inspector. Inspector evaluates the report; takes action according to tolerance guidelines in Part 18; completes items 21 through 23 on the back of copies 1, 2, and 4; sends copy 2 to area supervisor, copy 4 to regional office, and files copy 1. Circuit supervisor initials copy 1 if he concurs with action taken. Area supervisor initials copy 2 if he concurs with action taken, and files this copy. \*

#### 20.10 MP FORM 23

See Chart 20.1. The inspector completes all six copies when submitting objective or selective phase specimens for biological residues. Mail copy five (confirmation copy) to regional or area office as instructed by RD. If a confirmation copy is not requested by regional office, leave copy five intact and submit with specimen. Attach four to sample. Enclose a self-addressed envelope to facilitate the laboratory's return of MP 23.

Print, type, or check all applicable entries as follows:

1. Name of State and number in lieu of circuit.

2-5. See MP Form 22.

6. Self-explanatory.

7. Self-explanatory.

Enter country name, code, establishment number, custom entry number, and MP 410 number.

8. When livestock or poultry originate from a premise with a history of biological residue violation and are being resampled under Selective Phase, also enter in the Ante-Mortem and Post-Mortem Remarks space of 16 "resample notification Nos. 1 or 2," as applicable.

\* (b) Distribution of Returned Forms

\* (1) Nonviolations. Laboratory

9. Enter control number for objective phase samples. Enter N/A unless specimens are submitted because of a special project. Identify special projects by name or number.

10. Enter N/A unless the specimen is one of a series submitted because of a study made of a particular lot, flock, or herd. If specimen is one of several in a series, place sample number (preprinted number) of previous specimen in this block.

11. Enter animal species or poultry class and code as listed below:

|             |               |
|-------------|---------------|
| Cattle - 01 | Young         |
| Calves - 02 | Chickens - 21 |
| Sheep - 03  | Turkeys - 22  |
| Goats - 04  | Ducks - 23    |
| Swine - 05  | Geese - 24    |
| Horses - 06 | Fowl - 25     |
| Other - 08  |               |

12. When submitting specimens for biological residue analysis, enter approximate age of animal or bird.

13. Enter sex of animal or bird. Check in all specimens sent for biological residues. M and F indicate male or female. N indicates neuter (steer, barrow, etc.).

14. Check appropriate box. Each request for a specific test, analysis, etc., requires a separate MP 23.

Should more than one MP 23 be completed, enter sample number (preprinted number on upper right corner of the form) of related specimens in No. 10, "Related Sample Nos."

15. Check appropriate box indicating tissue submitted. If specimen is not listed, check box 06. Do not make any entries in this block when submitting samples from imported product.

16. Use when submitting samples from imported product for biological residues.

Enter product name under ante- and post-mortem remarks, and product code under "Code." See Part 27 for import product codes. When product is retained pending laboratory results,

enter such information in this block. If the laboratory results are to be telephoned or wired collect to the plant, include name, address, and phone number of plant where product is held or where inspector can be reached.

17. When submitting specimens for diagnostic purposes, the veterinarian shall enter his clinical diagnosis. This information is helpful to the pathologist.

18. Self-explanatory.

19-25. For laboratory use, except "Control Total (19)" to be entered by Automated Data Processing (ADP).

#### 20.11 MP FORM 403

See Chart 20.1. Complete and mail weekly to the Field Data Service Office, Chicago, Illinois, to report slaughter and related ante- and post-mortem inspection activities.

It summarizes information in Forms MP 402-2, 403-6 and VS 6-35.

MP Form 403 is prepared:

1. Weekly for each species slaughtered. The dispositions and slaughter figures are totaled for each species and submitted on an MP 403 dated for the week ending each Saturday.

2. To report "no kill" for a species not slaughtered during the week.

3. When a plant suspends operations. The "suspended operations" report indicates that temporary ceasing of slaughter operations was a planned event--repairs, maintenance, etc. This entry signals that further reports are not anticipated until a specified date.

4. To report "withdrawn" from slaughter operations. Further reports are not expected.



## (a) Routine Report

Complete MP Form 403 (Exhibit B) by writing entries in the following blocks:

Circuit name. The 5 digit State/Circuit code covering the plant (see MPI Directive 908.1).

Date. Use the Saturday date for the week reported. Write in "Week Ending" above the date block for the weekly summary.

Establishment number. Letters ("TA") should not be used unless they are part of the official number. Do not use "TA" to identify Talmadge-Aiken plants.

Species. Check name of species being slaughtered. For cattle enter total number of: (1) bulls, (2) steers, (3) cows, and (4) heifers. Mules and other equines should be reported as horses.

Total hours. Record production time to nearest one-quarter hour (15 minutes- 1/4 hour; 30 minutes- 1/2 hour; 45 minutes- 3/4 hour). Example 6 - 3/4.

Production time. It includes production delays to correct improper procedures by plant employees. Short delays (less than 5 minutes) for routine production difficulties should be included as production time.

Nonproduction time. It includes breakdown, coffee break, lunch period, changeover time from one species to another, and similar delays of 5 or more minutes.

Shift. Leave blank.

Total Slaughter. Total number of inspected animals regardless of disposition.

Slaughter Rate. Leave blank.

(1) Retained carcass and/or parts.

(i) Disposition. Report only dispositions made by the inspector. Do not report any disposition made by the plant. Dispositions of carcasses retained pending laboratory results shall be reported for the week the results are received.

(ii) Diseases or conditions. Some

common diseases and conditions are listed with their respective code numbers on MP 403. Other diseases not specified on MP 403 may be found in the list of diseases and conditions. See Exhibit C.

The veterinarian will use his professional knowledge for entering findings on MP 403 of a disease or condition not listed in Exhibit C. The list should not in any way influence the veterinarian's preparation of MP Form 403-6. If a code is not known, leave the code column blank. Do not record brucellosis reactors on MP 403.

(iii) Numbers of diseases or conditions. Record the number of all reportable diseases and conditions found. However, do not make multiple entries if one of the pathological conditions--i.e., emaciation, icterus, nephritis--is a symptom of or the result of another disease or pathological condition in same carcass. For example, report an icteric carcass affected with anaplasmosis only once as anaplasmosis. Refer to Exhibit C for recording diseases not listed on MP 403.

Letters found in upper left corner of entry boxes for "Disease or Condition" identify the point in inspection where the disease or condition was first determined for inspector's disposition. Letters are interpreted as follows:

R - Carcasses retained from regular kill.

S - Carcasses from animals marked "U.S. Suspect" on ante-mortem inspection.

A - Animals condemned on ante-mortem inspection.

T - Parts condemned. For reporting purposes, a "part" is:

1. Whole head (including tongue) of any species.

2. Hindlimb of any species disarticulated at the coxfemoral joint.

3. Forelimb of any species, removed with the scapula.

|              |                                 |             |   |                 |                |  |           |                   |          |             |  |
|--------------|---------------------------------|-------------|---|-----------------|----------------|--|-----------|-------------------|----------|-------------|--|
| (2)          |                                 |             |   |                 |                |  |           |                   |          |             |  |
| CIRCUIT NAME |                                 | DATE        |   | ESTABLISHMENT   |                | SPECIES (Check)  |           | OTHER B (Specify) |          |             |  |
| (1)          |                                 | MO. DA. YR. |   | (3)             |                | (4) CATTLE 1 <input type="checkbox"/> CALVES 2 <input type="checkbox"/> SHEEP 3 <input type="checkbox"/> |           |                   |          |             |  |
|              |                                 |             |   |                 |                | GOATS 4 <input type="checkbox"/> SWINE 5 <input type="checkbox"/> HORSES 6 <input type="checkbox"/>      |           |                   |          |             |  |
| TOTAL HOURS  | SHIFT (Circle where applicable) |             |   | TOTAL SLAUGHTER | SLAUGHTER RATE | FOR CATTLE GIVE  | NO. BULLS | NO. STEERS        | NO. COWS | NO. HEIFERS |  |
| (5)          | (6)                             |             |   | (7)             | (8)            |  |           | (9)               |          |             |  |
|              | 1                               | 2           | 3 |                 |                |  | 1         | 2                 | 3        | 4           |  |

(1)

Circuit names are no longer entered. Use this space to enter New State/Circuit Codes. See MPI Directive 908.1 - Example: State/Circuit - 536-20

\* (2)

Enter numbers only. Write "week ending" above for weekly summary.

(3)

If this entry is blank, unreadable, or wrong, your report will not be recorded.

\* (4)

Check one: Cattle, Calves, Sheep, Goats, Swine, or Horses. Mules and other equine-check "Horses".

\* (5)

Production time to nearest one-quarter hour.  $1/4 = 15$  minutes,  $1/2 = 30$  minutes, and  $3/4 = 45$  minutes. Enter the fractions.

\* (6)

Leave blank.

\* (7)

Enter total animals slaughtered.

\* (8)

Leave blank.

\* (9)

For cattle only enter the totals by sex. All sex totals should equal total slaughter.





UNITED STATES DEPARTMENT OF AGRICULTURE  
FOOD SAFETY AND QUALITY SERVICE  
MEAT AND POULTRY INSPECTION PROGRAM  
WASHINGTON, D.C. 20250

MEAT AND POULTRY INSPECTION REGULATIONS

AUGUST 1977

CHANGE: 77-8

MAINTENANCE INSTRUCTIONS

| Remove Page                              | Insert Page (numbered 77-8 ) |
|--|------------------------------|
| v  | v                            |
| vi                                       | vi                           |
| -----                                    |                              |
| SUBCHAPTER A - MANDATORY MEAT INSPECTION |                              |
| xi                                       | xi                           |
| xii                                      | xii                          |
| -----                                    |                              |
| 57                                       | 57                           |
| 58                                       | 58                           |
| -----                                    |                              |
| 173                                      | 173                          |
| 174                                      | 174                          |
| -----                                    |                              |
| 175                                      | 175                          |
| 176                                      | 176                          |



SOUTHWESTERN REGIONAL OFFICE:

(If you're in Arkansas, Kansas, Louisiana, Missouri, New Mexico, Oklahoma, or Texas, please contact):

\* Dr. W. H. Irvin, Director  
Room 5-F41  
1100 Commerce St.  
Dallas, TX 75245  
Phone: 8/749-3747 FTS  
214/749-3747 Commercial

Texas - New Mexico Area

\* Dr. John C. Schweda  
First National Life Bldg.  
Room 203-A  
702 Colorado  
Austin, TX 78701  
Phone: 8/734-5151 FTS  
512/397-5151 Commercial

Arkansas - Oklahoma Area

Dr. William D. O'Mara  
San Jose Manor Bldg., 2nd Floor  
216-1/2 East Emma Avenue  
Springdale, AR 72764  
Phone: 8/740-0603 FTS  
501/751-8412 Commercial

Missouri Area

\* Dr. Harlan D. Ellis  
Room B-26, Baptist Bldg.  
400 East High Street  
Jefferson City, MO 65101  
Phone: 8/276-5521 FTS  
314/635-0258 Commercial

Kansas Area

Dr. C. C. Hamilton  
Room 399, Federal Bldg.  
444 Southeast Quincy  
Topeka, KS 66683  
Phone: 8/752-2765 FTS  
913/295-2765 Commercial

Louisiana Area

Dr. Columbus B. Parsons  
Federal Bldg., Room 334  
750 Florida Avenue  
Baton Rouge, LA 70821  
Phone: 8/687-4397 FTS  
504/387-0181, ext. 397  
Commercial

WESTERN REGIONAL OFFICE:

(If you're in Alaska, Arizona, California, Colorado, Hawaii, Idaho, Montana, Nevada, North Dakota, Oregon, South Dakota, Utah, Washington, Wyoming, Samoa, or Guam, please contact):

Dr. L. J. Rafoth, Director  
Bldg. 2 C  
620 Central Avenue  
Alameda, CA 94501  
Phone: 8/536-7402 FTS  
415/273-7402 Commercial

Montana - Wyoming Area

Dr. Henry C. Hairston  
400 North Main Street, Room 303  
Butte, MT 59701  
Phone: 8/585-2331 FTS  
406/792-8413 Commercial

Colorado - Utah Area

Dr. D. W. Anderson  
2995 Baseline Road  
Suite 105  
Boulder, CO 80303  
Phone: 8/323-4411 FTS  
303/499-1000, Ext. 4411  
Commercial

California, Arizona, and Nevada Area

Dr. Wilson S. Horne  
83 Scripps Drive  
Sacramento, CA 95825  
Phone: 8/468-4554 FTS  
916/484-4554 Commercial

Hawaii, Idaho, Oregon, Guam,  
American Samoa Area

Dr. R. A. Moody  
4263 Commercial Street, SE.  
Salem, OR 97302  
Phone: 8/422-5831 FTS  
503/399-5831 Commercial

North Dakota - South Dakota Area

Dr. C. Schilmoeller  
Room 211, Federal Bldg.  
655 First Avenue, North  
Fargo, ND 58102  
Phone: 8/783-5641 FTS  
701/237-5771, Ext. 641  
Commercial

Washington - Alaska Area

Dr. John W. Howder  
711 S. Capitol Way, Fifth Floor  
P.O. Box 2167  
Olympia, WA 98507  
Phone: 8/434-9497 FTS  
206/753-9497 Commercial



- 325.2 Parcel post and ferries deemed carriers.
- 325.3 Product transported within the United States as part of export movement.
- 325.4 U.S. inspected, passed, and marked product; certificate.
- 325.5 Unmarked inspected product transported under official seal between official establishments for further processing; certificate.
- 325.6 Shipment of paunches between official establishments under official seal; certificate.
- 325.7 Shipment of products requiring special supervision between official establishments under official seal; certificate.
- 325.8 Transportation of certain undenatured lungs or lung lobes from official establishments or in commerce; provisions and restrictions.
- 325.9 (Reserved)
- 325.10 Returned products: certificate; permit; and other requirements.
- 325.11 Inedible articles: denaturing and other means of identification; certificate; exceptions.
- 325.13 Denaturing procedures.
- 325.14 Certificates, retention by carrier.
- 325.15 Evidence of proper certification required on waybills; transfer bills, etc., for shipment by connecting carrier; forms of statement.
- 325.16 Official seals; form, use, and breaking.
- 325.17 Loading or unloading products in sealed railroad cars, trucks, etc., en route prohibited; exception.
- \* 325.18 Diverting of shipments, breaking of seals, and reloading by carrier in emergency; reporting to Regional Director. \*
- 325.19 Provisions inapplicable to specimens for laboratory examination, etc., or to naturally inedible articles.
- 325.20 Transportation and other transactions concerning dead, dying, disabled, or diseased livestock, and parts of carcasses of livestock that died otherwise than by slaughter.
- 325.21 Means of conveyance in which dead, dying, disabled, or diseased livestock and parts of carcasses thereof shall be transported.

#### PART 327-IMPORTED PRODUCTS

##### Sec.

- 327.1 Application of provisions.
- 327.2 Eligibility of foreign countries for importation of products into the United States.
- 327.3 No product to be imported without compliance with applicable regulations.
- 327.4 Imported products; foreign certificates required.
- 327.5 Importer to make application for inspection; information required.
- 327.6 Import products; Program inspection; time and place.
- 327.7 Products for importation; movement prior to inspection; sealing; handling; bond; assistance.
- 327.8 Import products; equipment and means of conveyance used in handling to be maintained in sanitary condition.
- 327.9 Burlap wrapping for foreign meat.
- 327.10 Samples; inspection of consignments; refusal of entry; marking.

- 327.11 Receipts to importers for import product samples.
- 327.12 Foreign canned or packaged products bearing trade labels; sampling and inspection.
- 327.13 Foreign products offered for importation; reporting of findings to customs; handling of articles refused entry.
- 327.14 Marking of products and labeling of immediate containers thereof for importation.
- 327.15 Outside containers of foreign products; marking and labeling; application of official inspection legend.
- 327.16 Small importations for importer's own consumption; requirements.
- 327.17 Returned United States inspected and marked products.
- 327.18 Imported products to be handled and transported as domestic; entry into official establishments; exception.
- 327.19 Specimens for laboratory examination and similar purposes.
- 327.20 Importation of foreign inedible fats.
- 327.21 Special inspection procedures for chilled, fresh or frozen boneless manufacturing meat.
- 327.22 Official import meat inspection marks and seals.

#### PART 329-DETENTION; SEIZURE AND CONDEMNATION; CRIMINAL OFFENSES

##### Sec.

- 329.1 Article or livestock subject to administrative detention.
- 329.2 Method of detention; form of detention tag.
- 329.3 Notification of detention to the owner of the article or livestock detained, or his agent, or person having custody.
- 329.4 Notification of governmental authorities having jurisdiction over article or livestock detained; form of written notification.
- 329.5 Movement of article or livestock detained; removal of official marks.
- 329.6 Articles or livestock subject to judicial seizure and condemnation.
- 329.7 Procedure for seizure, condemnation, and disposition.
- 329.8 Authority for condemnation or seizure under other provisions of law.
- 329.9 Criminal offenses.

#### PART 330 (RESERVED)

#### PART 331-SPECIAL PROVISIONS FOR DESIGNATED STATES AND TERRITORIES; AND FOR DESIGNATION OF ESTABLISHMENTS WHICH ENDANGER PUBLIC HEALTH AND FOR SUCH DESIGNATED ESTABLISHMENTS

##### Sec.

- 331.1 Definition of "State."
- 331.2 Designation of States under paragraph 301(c) of the Act.
- 331.3 States designated under paragraph 301(c) of the Act; application of regulations.
- 331.4 Control and disposal of non-federally-inspected products in States designated under paragraph 301(c) of the Act.
- 331.5 Criteria and procedure for designating establishments with operations which would clearly endanger the public health; disposition of products; application of regulations.
- 331.6 Designation of States under section 205 of the Act; application of sections of the Act and the regulations.



\*

For application to burlap, muslin, cheesecloth, heavy paper, or other acceptable material that encloses carcasses or parts of carcasses.

(b) (1) The official inspection legend required by Part 317 of this subchapter to be shown on all labels for inspected and passed products of cattle, sheep, swine, and goats shall be in the following form except that it need not be of the size illustrated, provided that it is a sufficient size and of such color as to be conspicuously displayed and readily legible and the same proportions of letter size and boldness are maintained as illustrated:



(2) This official mark shall be applied by mechanical means and shall not be applied by a hand stamp.

(3) The official inspection legend described in subparagraph (1) of this paragraph may also be used for purposes of Part 316 of this subchapter on shipping containers, band labels, artificial casings, and other articles with the approval of the Administrator.

(c) Any brand, stamp, label, or other device approved by the Administrator and bearing any official mark prescribed in paragraph (a) or (b) of this section shall be an official device for purposes of the Act.

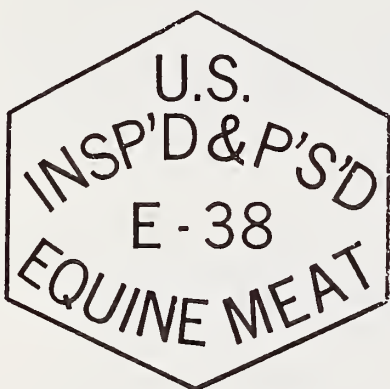


§ 312.3 Official marks and devices to identify inspected and passed equine products.

(a) The official inspection legend required by § 316.12 or § 317.2 of this subchapter to identify inspected and passed horse carcasses and parts of carcasses, or horse meat food products shall be in the appropriate form as hereinafter specified:<sup>1</sup>



(b) The official inspection legend required by § 316.12 or § 317.2 of this subchapter to identify inspected and passed mule and other (nonhorse) equine carcasses and parts of carcasses, or equine meat food products shall be in whichever of the following form, is appropriate:<sup>1</sup>



---

<sup>1</sup> The number "38" is given as an example only. The establishment number of the official establishment where the product is prepared shall be used in lieu thereof.



manner that it cannot easily and readily be removed by washing or soaking. A sufficient amount of the appropriate agent shall be used to give the material a distinctive color, odor, or taste so that such material cannot be confused with an article of human food.

(b) Inedible rendered animal fats shall be denatured by thoroughly mixing therein denaturing oil, No. 2 fuel oil, brucine dissolved in a mixture of alcohol and pine oil or oil of rosemary, finely powdered charcoal, or any proprietary denaturing agent approved for the purpose by the Administrator in specific cases. The charcoal shall be used in no less quantity than 100 parts per million and shall be of such character that it will remain suspended indefinitely in the liquid fat. Sufficient of the chosen identifying agents shall be used to give the rendered fat so distinctive a color, odor, or taste that it cannot be confused with an article of human food.

§ 325.14 Certificates, retention by carrier.

All original certificates delivered to a carrier in accordance with this part shall be filed separate and apart from all its other papers and records or identified in such a manner as to be readily checked by Department employees. Every certificate required to be maintained under this part shall be retained for a period of 2 years after December 31 of the year in which the transaction has occurred.

§ 325.15 Evidence of proper certification required on waybills; transfer bills, etc., for shipment by connecting carrier; forms of statement.

(a) All waybills, transfer bills, running slips, conductor's cards, or other papers accompanying a shipment, in the course of importation or otherwise in commerce, of any product shall have embodied therein, stamped thereon, or attached thereto a signed statement which shall be evidence to connecting carriers that the proper shipper's certificate, as required by § 325.4, § 325.5, § 325.6, § 325.7, § 325.10, or § 325.11, is on file with the initial carrier; and no connecting carrier shall receive for transportation or transport in the course of importation or otherwise in commerce any product unless the waybill, transfer bill, running slip, conductor's card, or other paper accompanying the same includes the aforesaid signed statement in the appropriate one of the following forms:

(1) When shipment is made under § 325.4, § 325.5, § 325.6, or § 325.7:

.....  
(Name of transportation company)  
U.S. inspected and passed, as evidenced by shipper's certificate on file with initial carrier.

(Signed).....Agent.

(2) When shipment is made under § 325.10:

.....  
(Name of transportation company)  
U.S. inspected and passed product alleged to be adulterated or misbranded as evidenced by permit and shipper's certificate on file with initial carrier.

(§ 325.15(a)(2) continued)

(Signed).....Agent.

(3) When shipment is made under § 325.11:

.....  
(Name of transportation company)

Adulterated, misbranded, or nonfederally inspected product which has been denatured or otherwise identified as required by the Federal Meat Inspection Regulations, as evidenced by shipper's certificate on file with initial carrier.

(Signed).....Agent.

(b) Signatures of agents to statements required under this section shall be written in full.

(c) No statement as prescribed in this section is required for the transportation of any animal food if it is eligible for transportation in commerce without a shipper's certificate under § 325.11(e).

§ 325.16 Official seals; forms, use, and breaking.

(a) The official seals required by this part shall be those prescribed in § 312.5(a) of this subchapter.

(b) Except as provided in § 325.18(b), official seal affixed under this part shall be affixed or broken only by Program employees, and no person other than a Program employee shall affix, detach, break, change, or tamper with any such seal in any way whatever. Commission of any such acts contrary to this regulation is a criminal offense.

§ 325.17 Loading or unloading products in sealed railroad cars, trucks, etc., en route prohibited; exception.

Unloading any product from an officially sealed railroad car, truck, or other means of conveyance containing any unmarked product or loading any product or any other commodity in the means of conveyance while en route from one official establishment to another official establishment is not permitted, except that product transported under § 325.5 from one official establishment to another for further processing may be unloaded and stored in transit at any approved warehouse which is operated under the identification service provided under the regulations in Part 350 of Subchapter B of this chapter and which has railroad facilities or a receiving dock for unloading the product directly into such warehouse: Provided, That the product is stored in rooms which are of such size and type as will not result in adulteration or misbranding of the product: And provided further, That the product is transported to and from such warehouse, and under official seal as provided in § 325.5 and stored in such rooms at such warehouse.

§ 325.18 Diverting of shipments, breaking of seals, and reloading by carrier in emergency; reporting to Regional Director.

\*

(a) Shipments of inspected and passed product that bear the inspection legend may be diverted from the original destination without a reinspection of the articles, provided the waybills, transfer bills, running slips, conductor's

(§ 325.18(a) continued)

card, or other papers accompanying the shipments are marked, stamped, or have attached thereto signed statements in accordance with § 325.15.

(b) In case of wreck or similar extraordinary emergency, the Department seals on a railroad car or other means of conveyance containing any inspected and passed product may be broken by the carrier, and if necessary, the articles may be reloaded into another means of conveyance, or the shipment may be diverted from the original destination, without another shipper's certificate; but in all such cases the carrier shall immediately report the facts by  
\* telephone or telegraph to the Regional Director in the area in which the \*  
\* emergency occurs. Such report shall include the following information: \*

- (1) Nature of the emergency.
- (2) Place where seals were broken.
- (3) Original points of shipment and destination.
- (4) Number and initial of the original car or truck.
- (5) Number and initials of the car or truck into which the articles are reloaded.
- (6) New destination of the shipment.
- (7) Kind and amount of articles.

§ 325.19 Provisions inapplicable to specimens for laboratory examination, etc., or to naturally inedible articles.

The provisions of this Part do not apply:

(a) To specimens of product sent to or by the Department of Agriculture or divisions thereof in Washington, D.C., or elsewhere, for laboratory examination, exhibition purposes, or other official use;

(b) To material released for educational, research, and other nonfood purposes, as prescribed in § 314.9 of this subchapter;

(c) To glands and organs for use in preparing pharmaceutical, organotherapeutic, or technical products and not used for human food, as described in § 318.1(g) of this subchapter;

(d) To material or specimens of product for laboratory examination, research, or other nonhuman food purposes, when authorized by the Administrator, and under conditions prescribed by him in specific cases; and

(e) To articles that are naturally inedible by humans, such as hoofs, horns, and hides in their natural state.

§ 325.20 Transportation and other transactions concerning dead, dying, disabled, or diseased livestock, and parts of carcasses of livestock that died otherwise than by slaughter.

No person engaged in the business of buying, selling, or transporting in commerce, or importing any dead, dying, disabled, or diseased animals or parts of the carcasses of any animals that died otherwise than by slaughter shall:

(a) Buy, sell, transport, or offer for sale or transportation, in commerce, or import any dead livestock if its hide or skin has been removed;





MEAT AND POULTRY INSPECTION (MPI)  
PUBLICATIONS

Issuances of the Meat and Poultry Inspection Program. This publication is published monthly by the Issuance Coordination Staff, and includes selected CFR amendments, MPI bulletins, and MPI directives; changes to the Meat and Poultry Inspection Manual; and changes to the Meat and Poultry Inspection Regulations. Subscription for 1 year (12 issues) is \$13.00 in U.S. and possessions, and \$16.25 in other countries; cost of one copy is \$1.25 in U.S. and possessions and \$1.75 in other countries.

Meat and Poultry Inspector Manual. This manual contains procedural guidelines and instructions useful in enforcing laws and regulations related to Federal meat and poultry inspection. Copy of the publication and change since its printing: \$16.50 in U.S. and possessions, and \$20.75 in other countries.

Meat and Poultry Inspector Regulations. This publication contains regulations for slaughter and processing of livestock, poultry, as well as for certain voluntary services and humane slaughter. Copy of the publication and changes since its printing: \$30.00 in U.S. and possessions, and \$37.50 in other countries.

\* Meat and Poultry Inspection Directory. This directory is published semiannually. Subscription for \*  
\* 1 year (two issues) is \$7.60 in U.S. and possessions, and \$9.50 in other countries; cost of one copy \*  
\* is \$3.80 in U.S. and possessions, and \$4.75 in other countries. \*

List of Chemical Compounds. Lists nonfood compounds authorized for use in plants operating under USDA Meat and Poultry, Rabbit and Egg Products Inspection Programs, and the U.S. Department of Commerce, Fishery Products Inspection Program. Cost of one copy is \$2.45 in U.S. and possessions, and \$3.05 in other countries.

U.S. Inspected Meatpacking Plants; A Guide to Construction, Equipment, Layout; Agriculture Handbook No. 191. This handbook is designed to supply interpretation of regulations and guidelines in designing, building, altering, and maintaining meatpacking plants to operate under Federal inspection. Cost of one copy is \$2.90 in U.S. and possessions, and \$3.65 in other countries.

Accepted Meat and Poultry Equipment. This publication is published three times yearly, contains information on equipment construction and acceptance, and lists commercially available equipment acceptable for use in federally inspected meat and poultry plants. Subscription for 1 year (three issues) is \$5.65 in U.S. and possessions, and \$7.10 in other countries; cost of one copy is \$1.90 in U.S. and possessions, and \$2.40 in other countries.

---

#### HOW TO ORDER

Persons, other than MPI personnel, should write to the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402. Check or money order should be made payable to the Superintendent of Documents and should be mailed with the request.

#### CORRESPONDENCE

Correspondence on subscriptions should be addressed to the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Correspondence on the contents should be addressed to USDA, FSQS, MPI, Issuance Coordination Staff, Washington, D.C. 20250.

Correspondence on mailing and distribution should be addressed by MPI personnel through regional director, and by State personnel through State program director and MPI regional director to USDA, FSQS, Administrative Services Division, Room 727-A, Federal Building, Hyattsville, Maryland 20782.

**UNITED STATES DEPARTMENT OF AGRICULTURE  
Food Safety and Quality Service**

Washington, D. C. 20250

Official Business

Penalty for Private Use, \$300

POSTAGE AND FEES PAID  
U.S. DEPARTMENT OF  
AGRICULTURE  
AGR 101  
**FIRST CLASS**

